

Date: Monday, 1/23/2006 7:55:59 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 03.250 SUPPORT
Job Number	: 25594		
Estimate Number	: 10387		
P.O. Number	: NIA	Part Number	: D29401
This Issue	: 1/23/2006 S.O. No. : NIA	Drawing Number	: D2940 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : PURCHASED PARTS	Drawing Revision	: A1
Previous Run	: 24367	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/20/2006
Checked & Approved By	: <u>SEE ABOVE USER &amp; DATE</u>	Qty:	12 Um: Each
Comment	: Est. C 02.11.26 Reformat; Added P/O KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6104007	17-4 SS Roundbar 4.50"OD
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

17-4 SS Roundbar 4.50"OD

D6104-007

BATCH: B25594A

2.0	25594A	ROUND BILLET 17-4
-----	--------	-------------------



Comment: Sub-Component ROUND BILLET 17-4

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



RG Issue PO for turning only  
P.O. 1684



u 0603.01

Comment: MORI SEIKI CNC LATHE LARGE

Turn blank for Haas as per Folio FA079

RG Receive & Inspect for visual damage

020403/21 (36)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

1 Ep 06/05/01

5.0	BAND SAW HAAS	BAND SAW
-----	---------------	----------



Comment: BAND SAW HAAS

1- Machine as per Folio FA079

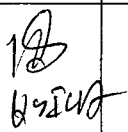
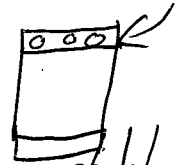


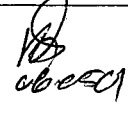
2- Tumble & Deburr

1 Ep 06/05/01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 9 Date: 06/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/08	#50	hole location off on <del>by</del> by 0.022" then, x origin was on part not on picture.		 <del>etc</del> acceptable deviation tooling holes		 060501		 060501

NOTE: Date & initial all entries

Date: Monday, 1/23/2006 7:55:59 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 25594

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

1 En 06/05/01

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.05.03

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

9.m 06-05-03

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

4/5/5

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 374

11/05/05 + 4/5/5

(72)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/08

(72)

Job Completion



u 06-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 25594	
<b>Description:</b> Ø3.250 Support				<b>Part Number:</b> D2940-1	
<b>Inspection Dwg:</b> D2940 Rev. A1				<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		3.212	✓		✓		
B	4.946	4.966		4.956	4.956	4.955	4.954		
C	0.718	0.738		0.728	0.726	0.723	0.724		
D	0.090	0.110		0.089	0.100	0.100	0.101		
E	3.564	3.584		3.573	3.573	3.573	3.573		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.454	3.452	3.453	3.454		
H	0.112	0.132		0.118	0.118	0.119	0.118		
I	2.170	2.190		2.178	2.180	2.183	2.180		
J	4.451	4.471		4.461	4.460	4.462	4.460		
K	0.413	0.433		0.420	0.422	0.426	0.422		
L	0.913	0.933		0.920	0.924	0.929	0.923		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.152	0.155	0.154	0.146		
AD	3.510	3.530		3.524	3.524	3.525	3.523		
AE	1.633	1.673		1.660	1.662	1.662	1.664		
AF	1.493	1.513		1.503	1.504	1.503	1.506		
AG	0.040	0.060		0.048	0.051	0.054	0.049		
AH	0.188	0.193	DT8706	0.188	0.188	0.189	0.188		
AI	0.140	0.160		0.149	0.154	0.153	0.152		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.058	0.051	0.057	0.052		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.152	0.156	0.154	0.144		
AN	0.350	0.450		0.375	0.374	0.373	0.424		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.157	0.160	0.160	0.157		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	0.258	0.258	0.258	0.257		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.130	4.132	4.130	4.128		
AV									
AW									
<b>Accept/Reject</b>									

Measured by:	J. G. / Ep
Date:	06/04/20

Audited by:	MJ
Date:	06/04/20

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>25594</b>
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b>	<b>D2940-1</b>
<b>Inspection Dwg:</b> D2940 Rev. A1		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	S	6	7	8	By	Date
Lathe Section									
A	3.211	3.216		✓	✓	✓	✓		
B	4.946	4.966		4.957	4.954	4.954	4.955		
C	0.718	0.738		0.727	0.726	0.726	0.726		
D	0.090	0.110		0.101	0.099	0.098	0.099		
E	3.564	3.584		3.573	3.573	3.574	3.573		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.453	3.452	3.453	3.452		
H	0.112	0.132		0.118	0.118	0.119	0.118		
I	2.170	2.190		2.179	2.178	2.180	2.179		
J	4.451	4.471		4.463	4.463	4.462	4.461		
K	0.413	0.433		0.429	0.420	0.424	0.423		
L	0.913	0.933		0.923	0.927	0.928	0.919		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.149	0.152	0.149	0.148		
AD	3.510	3.530		3.522	3.522	3.524	3.524		
AE	1.633	1.673		1.664	1.665	1.665	1.660		
AF	1.493	1.513		1.509	1.510	1.510	1.510		
AG	0.040	0.060		0.057	0.050	0.051	0.050		
AH	0.188	0.193	DT8706	0.188	0.189	0.190	0.190		
AI	0.140	0.160		0.149	0.152	0.155	0.151		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.046	0.049	0.049	0.052		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.153	0.146	0.146	0.157		
AN	0.350	0.450		0.470	0.422	0.420	0.419		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.155	0.156	0.156	0.154		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698	✓	✓	✓	✓		
AS	0.257	0.262	DT8683	0.257	0.257	0.257	0.258		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.130	4.128	4.128	4.127		
AV									
AW									
Accept/Reject									

Measured by:	Ep / J.G	Audited by:	SD
Date:	06/04/30	Date:	06/04/30

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 25594	
<b>Description:</b> Ø3.250 Support				<b>Part Number:</b> D2940-1	
<b>Inspection Dwg:</b> D2940 Rev. A1				<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		✓	✓	✓	✓	CP 06/04/20	
B	4.946	4.966		4.956	4.954	4.956	4.955		
C	0.718	0.738		0.724	0.728	0.727	0.726		
D	0.090	0.110		0.098	0.101	0.098	0.099		
E	3.564	3.584		3.575	3.575	3.574	3.572		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.452	3.458	3.453	3.453		
H	0.112	0.132		0.118	0.119	0.119	0.120		
I	2.170	2.190		2.185	2.185	2.180	2.180		
J	4.451	4.471		4.460	4.462	4.460	4.460		
K	0.413	0.433		0.418	0.419	0.417	0.427		
L	0.913	0.933		0.924	0.920	0.918	0.926		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260		0.250	0.256	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.158	0.155	0.157	0.158		
AD	3.510	3.530		3.523	3.522	3.522	3.523		
AE	1.633	1.673		1.660	1.665	1.665	1.660		
AF	1.493	1.513		1.499	1.500	1.499	1.505		
AG	0.040	0.060		0.047	0.051	0.049	0.051		
AH	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AI	0.140	0.160		0.148	0.152	0.152	0.156		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.044	0.051	0.051	0.053		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.147	0.152	0.149	0.149		
AN	0.350	0.450		0.425	0.412	0.419	0.425		
AO	0.240	0.260		0.250	0.256	0.250	0.250		
AP	0.150	0.170		0.166	0.156	0.157	0.167		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698	✓	✓				
AS	0.257	0.262	DT8683	0.257	0.258	0.258	0.258		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.130	4.128	4.127	4.130		
AV									
AW									
<b>Accept/Reject</b>									

Measured by:	En / J G
Date:	06/04/20

Audited by:	SA
Date:	06/04/20

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

<b>ART AEROSPACE LTD</b>		<b>Work Order:</b>	25594
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b>	D2940-1
<b>Inspection Dwg:</b> D2940 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		✓	✓	✓	✓	C 06/04/20	
B	4.946	4.966		4.954	4.954	4.955	4.955		
C	0.718	0.738		0.726	0.726	0.725	0.726		
D	0.090	0.110		0.101	0.099	0.101	0.099		
E	3.564	3.584		3.574	3.573	3.573	3.573		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.454	3.453	3.453	3.453		
H	0.112	0.132		0.118	0.119	0.119	0.117		
I	2.170	2.190		2.181	2.179	2.186	2.179		
J	4.451	4.471		4.461	4.461	4.463	4.460		
K	0.413	0.433		0.422	0.419	0.425	0.425		
L	0.913	0.933		0.922	0.926	0.927	0.916		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.150	0.152	0.148	0.149		
AD	3.510	3.530		3.520	3.523	3.523	3.528		
AE	1.633	1.673		1.664	1.660	1.662	1.664		
AF	1.493	1.513		1.507	1.503	1.507	1.504		
AG	0.040	0.060		0.047	0.044	0.050	0.052		
AH	0.188	0.193	DT8706	0.190	0.190	0.190	0.190		
AI	0.140	0.160		0.149	0.151	0.150	0.151		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.047	0.047	0.046	0.051		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.144	0.152	0.145	0.154		
AN	0.350	0.450		0.410	0.420	0.426	0.425		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.159	0.159	0.153	0.161		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.131	4.131	4.128	4.129		
AV									
AW									
Accept/Reject									

Measured by:	S.G / E
Date:	06/04/20

Audited by:	SD
Date:	06/04/20

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	



## ART AEROSPACE LTD

Work Order:

25594

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B &amp; record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
Lathe Section									
A	3.211	3.216		✓	✓	✓	✓		
B	4.946	4.966		4.955	4.956	4.956	4.957		
C	0.718	0.738		0.721	0.722	0.722	0.727		
D	0.090	0.110		0.100	0.099	0.099	0.099		
E	3.564	3.584		3.575	3.574	3.574	3.573		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.453	3.453	3.451	3.450		
H	0.112	0.132		0.119	0.120	0.119	0.115		
I	2.170	2.190		2.180	2.180	2.181	2.179		
J	4.451	4.471		4.460	4.459	4.461	4.462		
K	0.413	0.433		0.423	0.423	0.414	0.417		
L	0.913	0.933		0.920	0.923	0.931	0.920		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.157	0.153	0.147	0.156		
AD	3.510	3.530		3.525	3.522	3.526	3.523		
AE	1.633	1.673		1.661	1.665	1.662	1.665		
AF	1.493	1.513		1.505	1.508	1.506	1.510		
AG	0.040	0.060		0.051	0.049	0.049	0.050		
AH	0.188	0.193	DT8706	0.190	0.190	0.190	0.189		
AI	0.140	0.160		0.154	0.152	0.149	0.154		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.047	0.048	0.047	0.046		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.146	0.144	0.144	0.145		
AN	0.350	0.450		0.431	0.425	0.422	0.430		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.154	0.156	0.156	0.157		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698	—	—	—	—		
AS	0.257	0.262	DT8683	0.258	0.257	0.258	0.257		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.130	4.127	4.129	4.127		
AV									
AW									
Accept/Reject									

Measured by:

En/ J.G

Date:

06/04/20

Audited by:

S.D

Date:

06/04/20

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

ART AEROSPACE LTD		Work Order:	25594
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
Lathe Section									
A	3.211	3.216		✓	✓	✓	✓	} CP 06/04/25	
B	4.946	4.966		4.954	4.954	4.954	4.951		
C	0.718	0.738		0.728	0.725	0.724	0.722		
D	0.090	0.110		0.096	0.096	0.097	0.101		
E	3.564	3.584		3.573	3.572	3.572	3.571		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.453	3.453	3.452	3.452		
H	0.112	0.132		0.115	0.116	0.119	0.119		
I	2.170	2.190		2.180	2.181	2.180	2.180		
J	4.451	4.471		4.460	4.462	4.462	4.461		
K	0.413	0.433		0.429	0.420	0.421	0.421		
L	0.913	0.933		0.925	0.916	0.923	0.922		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.148	0.143	0.148	0.144		
AD	3.510	3.530		3.522	3.523	3.522	3.520		
AE	1.633	1.673		1.662	1.665	1.666	1.660		
AF	1.493	1.513		1.509	1.507	1.512	1.511		
AG	0.040	0.060		0.050	0.045	0.051	0.049		
AH	0.188	0.193	DT8706	0.189	0.188	0.189	0.190		
AI	0.140	0.160		0.150	0.150	0.152	0.153		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.043	0.044	0.048	0.049		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.142	0.148	0.143	0.147		
AN	0.350	0.450		0.418	0.414	0.425	0.420		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.154	0.150	0.154	0.155		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698	✓	✓	✓	✓		
AS	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
AT	0.053	0.073		0.063	0.062	0.063	0.063		
AU	4.118	4.138		4.126	4.128	4.129	4.130		
AV									
AW									
Accept/Reject									

Measured by: En / J G	Audited by: SN
Date: 06/04/20	Date: 05/04/20

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

<b>ART AEROSPACE LTD</b>		<b>Work Order:</b>	25894
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b>	D2940-1
<b>Inspection Dwg:</b> D2940 Rev. A1		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	25	26	27	28	By	Date
<b>Lathe Section</b>									
A	3.211	3.216		✓	✓	✓	✓		
B	4.946	4.966		4.954	4.954	4.954	4.954		
C	0.718	0.738		0.724	0.720	0.721	0.720		
D	0.090	0.110		0.098	0.100	0.099	0.101		
E	3.564	3.584		3.574	3.574	3.573	3.574		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.453	3.453	3.453	3.453		
H	0.112	0.132		0.119	0.119	0.120	0.119		
I	2.170	2.190		2.181	2.181	2.180	2.181		
J	4.451	4.471		4.466	4.460	4.461	4.460		
K	0.413	0.433		0.415	0.413	0.414	0.415		
L	0.913	0.933		0.921	0.923	0.922	0.923		
M									
N									
<b>HAAS Section</b>									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.151	0.155	0.157	0.146		
AD	3.510	3.530		3.524	3.525	3.522	3.521		
AE	1.633	1.673		1.660	1.662	1.661	1.665		
AF	1.493	1.513		1.503	1.505	1.504	1.511		
AG	0.040	0.060		0.049	0.051	0.050	0.049		
AH	0.188	0.193	DT8706	0.190	0.190	0.190	0.189		
AI	0.140	0.160		0.154	0.155	0.155	0.152		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.049	0.050	0.051	0.049		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.151	0.153	0.152	0.141		
AN	0.350	0.450		0.412	0.390	0.410	0.427		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.154	0.160	0.155	0.154		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698	✓	✓	✓	✓		
AS	0.257	0.262	DT8683	0.258	0.258	0.258	0.257		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.129	4.130	4.129	4.129		
AV									
AW									
<b>Accept/Reject</b>									

Measured by: <b>S.G</b>	Audited by: <b>SD</b>
Date: <b>06/04/28</b>	Date: <b>06/04/28</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

ART AEROSPACE LTD		Work Order:	25594
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	29	30	31	32	By	Date
Lathe Section									
A	3.211	3.216		✓	✓	✓	✓		
B	4.946	4.966		4.954	4.954	4.952	4.954		
C	0.718	0.738		0.720	0.718	0.728	0.721		
D	0.090	0.110		0.099	0.108	0.099	0.099		
E	3.564	3.584		3.573	3.572	3.572	3.572		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.453	3.455	3.454	3.454		
H	0.112	0.132		0.119	0.119	0.118	0.126		
I	2.170	2.190		2.185	2.185	2.180	2.179		
J	4.451	4.471		4.463	4.463	4.462	4.466		
K	0.413	0.433		0.433	0.433	0.424	0.420		
L	0.913	0.933		0.915	0.920	0.922	0.918		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.148	0.147	0.154	0.148		
AD	3.510	3.530		3.520	3.523	3.521	3.521		
AE	1.633	1.673		1.671	1.664	1.670	1.665		
AF	1.493	1.513		1.507	1.505	1.508	1.511		
AG	0.040	0.060		0.051	0.045	0.051	0.048		
AH	0.188	0.193	DT8706	0.188	0.190	0.188	0.190		
AI	0.140	0.160		0.157	0.152	0.152	0.149		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.049	0.048	0.047	0.048		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.147	0.144	0.143	0.142		
AN	0.350	0.450		0.470	0.414	0.410	0.426		
AO	0.240	0.260		0.252	0.250	0.250	0.250		
AP	0.150	0.170		0.155	0.158	0.167	0.154		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	0.257	0.257	0.257	0.259		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.130	4.129	4.133	4.126		
AV									
AW									
Accept/Reject									

Measured by:	En/ J.G
Date:	06/04/29

Audited by:	J.L
Date:	06/04/30

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

## ART AEROSPACE LTD

Work Order:

25594

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B &amp; record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	33	34	35	36	By	Date
Lathe Section									
A	3.211	3.216		✓	✓	✓	✓	/ep	06/04/20
B	4.946	4.966		4.955	4.955	4.953	4.958		
C	0.718	0.738		0.726	0.722	0.725	0.726		
D	0.090	0.110		0.097	0.098	0.097	0.102		
E	3.564	3.584		3.573	3.573	3.574	3.573		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.452	3.454	3.453	3.454		
H	0.112	0.132		0.120	0.119	0.119	0.118		
I	2.170	2.190		2.175	2.180	2.181	2.181		
J	4.451	4.471		4.462	4.462	4.463	4.461		
K	0.413	0.433		0.423	0.425	0.418	0.422		
L	0.913	0.933		0.930	0.917	0.920	0.922		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.148	0.150	0.150	0.148		
AD	3.510	3.530		3.524	3.524	3.521	3.521		
AE	1.633	1.673		1.665	1.665	1.665	1.657		
AF	1.493	1.513		1.508	1.511	1.510	1.503		
AG	0.040	0.060		0.047	0.048	0.051	0.054		
AH	0.188	0.193	DT8706	0.190	0.190	0.188	0.190		
AI	0.140	0.160		0.157	0.154	0.152	0.154		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.047	0.049	0.048	0.053		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.150	0.142	0.147	0.160		
AN	0.350	0.450		0.410	0.413	0.420	0.420		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.152	0.154	0.154	0.160		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698	✓	✓	✓	✓		
AS	0.257	0.262	DT8683	0.258	0.258	0.257	0.258		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.127	4.127	4.132	4.127		
AV									
AW									
Accept/Reject									

Measured by:

S. G. / ep

Date:

06/04/20

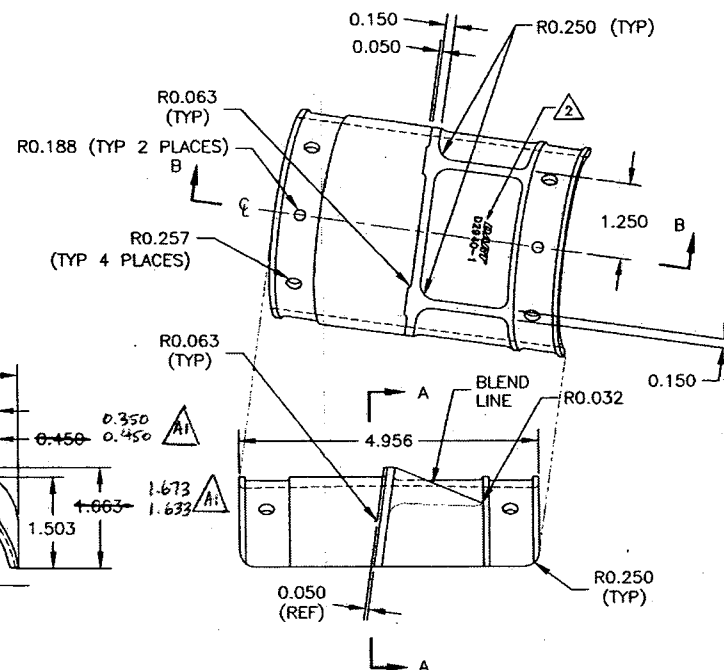
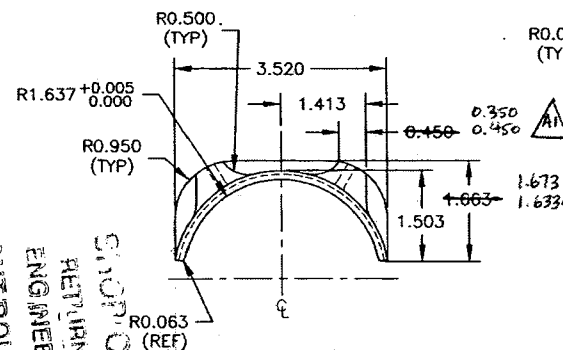
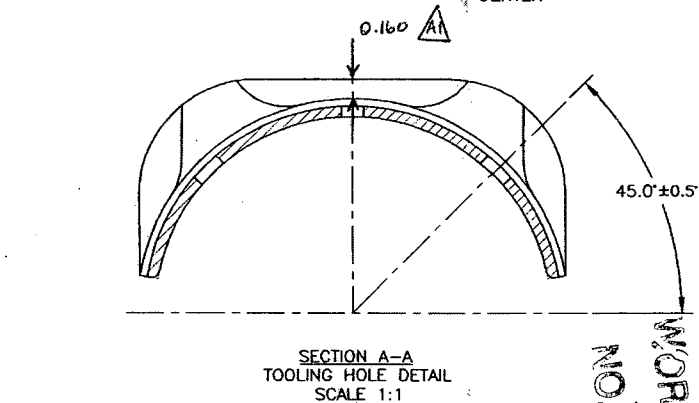
Audited by:

SA

Date:

06/04/20

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	



1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)

2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA  
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP

3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3

CONTROLLED COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITH OUT NOTICE  
WORK ORDER  
NO. 25594

RELEASED  
01.01.11

A1 <i>#</i> 02.04.04		UPDATE PER NCR 642	
A 01.01.10		NEW ISSUE	
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART</b>	DART AEROSPACE LTD. HARRISBURT, ONTARIO, CANADA
CHECKED <i>RT</i>	APPROVED <i>off</i>	DRAWING NO. D2940	REV. _____ SHEET 1 OF _____
DATE 01.01.10		TITLE 03.250 SUPPORT	

COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
36	DSK081	Support as per Dwg D2940-1	0684
15	DSK078	Support as per Dwg D2943-1	0684

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Shigi (Regula) Walz

Vankleek Hill, March 20, 2006